

Date: Thursday, 12/06/2008 12:44:57 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
 Job Number : 39830
 Estimate Number : 11668
 P.O. Number :
 This Issue : 12/06/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2845
 Drawing Number : D2845 REV A
 Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : A
 Material :
 Previous Run : 37339 Due Date : 19/06/2008 Qty: 10 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: B 00.11.01 Removed P/O for Powder Coat - in house processEC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 1.6109 f(s)/Unit Total: 16.1091 f(s)

304 RD Tube .500 x .035W

M304TRO500W035

Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 17.11" long (Hole ctr. to hole ctr.) using Jig

DT 8012

Batch M 108250

SR 08/06/12 (10)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Form per Dwg D2845 using brake and bending Jig DT 8238-C

Debur

PT 08-07-14 (10)

DE 08/06/16 (10)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/14 (10)

4.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 1:00pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 1:30pm

JA 08-07-14 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/06/2008 12:44:57 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 39830

Part Number: D2845

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-h

08/07/14

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 205

JS

08/07/15

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

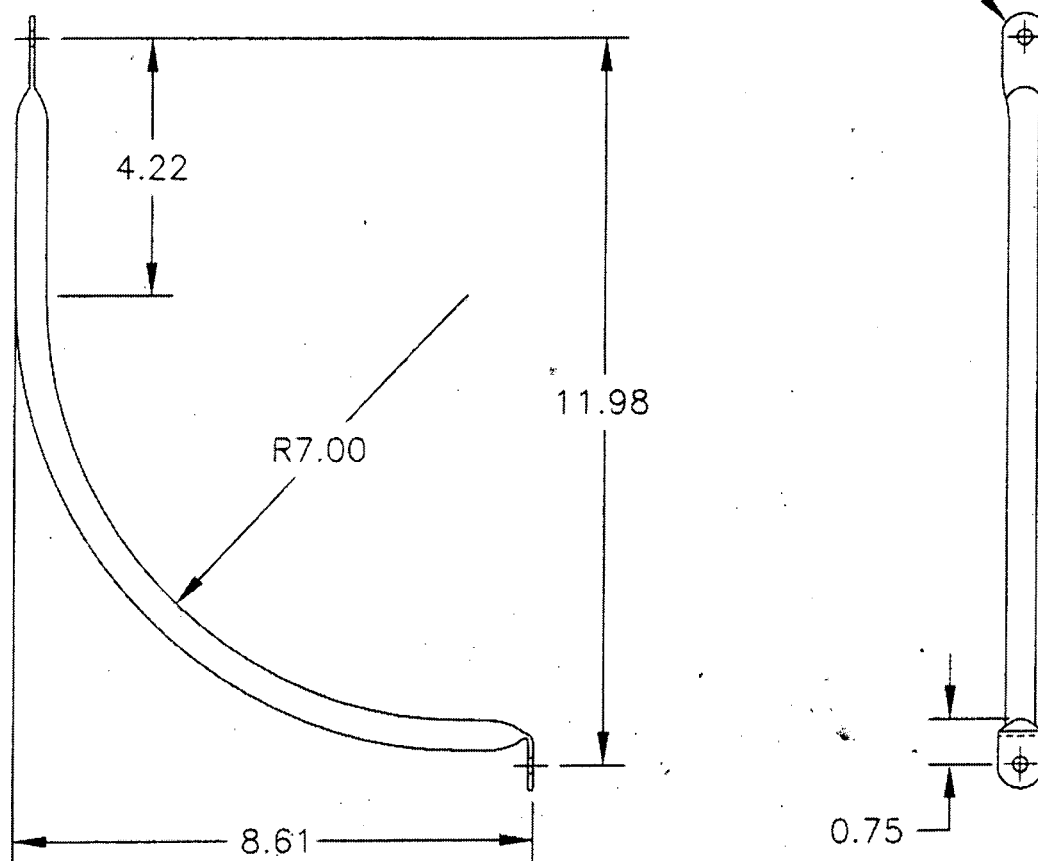
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>PH</i>	APPROVED <i>JS</i>	DRAWING NO. D2845	REV. A SHEET 1 OF 1
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
10.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3